

Date: Monday, 19/01/2009 2:05:40 PM
User: Julie Dawson

Process Sheet

| | | | |
|----------------------------------|--|-------------------------|-------------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : BEARPAW KIT (19"X24") |
| Job Number | : 44888 | | |
| Estimate Number | : 10323 | | |
| P.O. Number | : | Part Number | : D206559013 |
| This Issue | : 19/01/2009 | S.O. No. | : |
| Prsht Rev. | : NC | Drawing Number | : D2432 REV F3 |
| First Issue | : / / | Project Number | : N/A |
| Previous Run | : 44223 | Drawing Revision | : F3 |
| | Type | Material | : |
| | : MACHINED PARTS | Due Date | : 15/02/2009 |
| Written By | : | Qty: | 6 |
| Checked & Approved By | : <u>JUD 09.01.20</u> | Um: | Each |
| Comment | : Est Rev:J 04.02.17 Blank size changed KJ/JLM Est Rev:K 07-01-02 Was K10008 JLM Est Rev:L 08-01-09 Added Step 2 JLM Verified By:EC Est Rev:M 08-04-29 update seq. 8 and 12 DD verified by:EC Est Rev:N 08-10-15 New Manufacturing Method JLM Verified By:EC | | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|----|------------------|
| 1.0 | DC | DOCUMENT CONTROL |
|-----|----|------------------|



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-559-013 CHG005

8 09/02/12

| | | |
|-----|-----------------|-----------------|
| 2.0 | MFG ENGINEERING | MFG ENGINEERING |
|-----|-----------------|-----------------|



Comment: MFG ENGINEERING

Program Batch Number

JUD 09.02.02

| | | |
|-----|----------|---------------|
| 3.0 | MUHMWB10 | UHMW 1" Black |
|-----|----------|---------------|



Comment: Qty.: 3.4083 sf(s)/Unit Total : 20.4498 sf(s) X2

Material: Black UHMW 1"

(MUHMWB10)

Batch: 110721

18 9-2-6

(12) pieces

| | | |
|-----|-----------|----------------|
| 4.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET

Cut Blank as per D2432 File

18 9-2-6

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Part Number: D206559013

Job Number:



Seq. #: Machine Or Operation: Description :

5.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Note:(2) bearpaws for (1) Kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio and Dwg D2432 Identify as D2432F

3-Deburr

inf 09/02/08

(12)

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

inf 09/02/08

(12)

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

DIP 09/02/11

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

9.0

D2182B

Rubber Cushion



Comment: Qty.: 2.6000 f(s)/Unit Total : 15.6000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2182B050 Rubber Cushion

42737

JS 09/02/12 (16)

10.0

D2274

Radius Block



Comment: Qty.: 12.0000 Each(s)/Unit Total : 72.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 D2274 Radius Block

2 D2432F(ref only) Bearpaw

43838

JS 09/02/12 (16)

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Drawing Name: BEARPAW KIT (19"X24")

Job Number: 44888

Part Number: D206559013

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

D2438

Clamp



Comment: Qty.: 6.0000 Each(s)/Unit Total : 36.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2438

Clamp

43840

S (46)

SS 09/02/12 (x6)

12.0

D2529

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 72.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 D2529

Washer

42408

S (46)

SS 09/02/12 (x6)

13.0

D2732

Rubber Extrusion



Comment: Qty.: 2.6000 f(s)/Unit Total : 15.6000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2732-050

Rubber Cushion

38509

S (46)

SS 09/02/12 (x6)

14.0

AN415A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 72.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN4-15A

Bolt

M109148

S (46)

SS 09/02/12 (x6)

15.0

AN417A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 72.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN4-17A

Bolt

M109001

S (46)

SS 09/02/12 (x6)

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Part Number: D206559013

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

AN960JD416

Washer



Comment: Qty.: 24.0000 Each(s)/Unit Total : 144.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

24 AN960JD416 Washer M16523.

SS 09/02/12 (X6)

17.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 72.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 MS21042L4 Nut (or -4) M109202

SS 09/02/12 (X6)

18.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

SS 09/02/12 (X6)

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPPD206-559-013

Location: 13 A

9/2/12

(6k)

SP

20.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/17

Job Completion



U 81-02-13

| | | |
|------------------------------|----------------|----------------------------------|
| DART AEROSPACE LTD | | Work Order: <i>W11820</i> |
| Description: Bearpaw | | Part Number: D2432 |
| Inspection Dwg: D2432 | Rev: F3 | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

| Inspection Sheet Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|---------------------------------------|-------------|---------------------|-------------------|--------|-------------------------|----------|
| A | 0.063 x 45° | +0.030/-0.010 | <i>.055 x 45°</i> | — | | |
| B | 5.500 | +/-0.030 | <i>5.503</i> | — | | |
| C | 0.200 | +/-0.030 | <i>.202</i> | — | | |
| D | 0.25 x 45° | +/-0.030 | <i>.240 x 45°</i> | — | | |
| E | R0.250 | +/-0.030 | <i>R.250</i> | — | | |
| F | 0.250 | +/-0.010 | <i>.245</i> | — | | |
| G | 0.625 | +/-0.030 | <i>.610</i> | — | | |
| H | 0.375 | +/-0.010 | <i>.377</i> | — | | |
| I | 0.950 | +0.030/0.010 | <i>.945</i> | — | | |
| J | 19.000 | +/-0.030 | <i>19.000</i> | — | | |
| K | 3.14 | +/-0.030 | <i>3.145</i> | — | | |
| L | 3.28 | +/-0.030 | <i>3.290</i> | — | | |
| M | Ø0.260 | +0.005/-0.000 | <i>Ø.260</i> | — | | |
| N | Ø0.93 | +/-0.030 | <i>Ø.924</i> | — | | |
| O | 0.30 | +0.030/-0.000 | <i>.305</i> | — | | |
| P | 23.750 | +/-0.030 | <i>23.750</i> | — | | |
| Q | 7.375 | +/-0.030 | <i>7.375</i> | — | | |
| R | 4.250 | +/-0.010 | <i>4.250</i> | — | | |
| S | 2.000 | +/-0.030 | <i>2.000</i> | — | | |
| T | 9.000 | +/-0.010 | <i>9.000</i> | — | | |
| U | 9.000 | +/-0.010 | <i>9.000</i> | — | | |
| V | 0.375 | +/-0.010 | <i>.378</i> | — | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |

| | | |
|--------------------------------|-------------------------------|--------------------------------|
| Measured by: <i>gml</i> | Audited by: <i>DDP</i> | Prototype Approval: N/A |
| Date: <i>09/02/08</i> | Date: <i>09/02/11</i> | Date: |

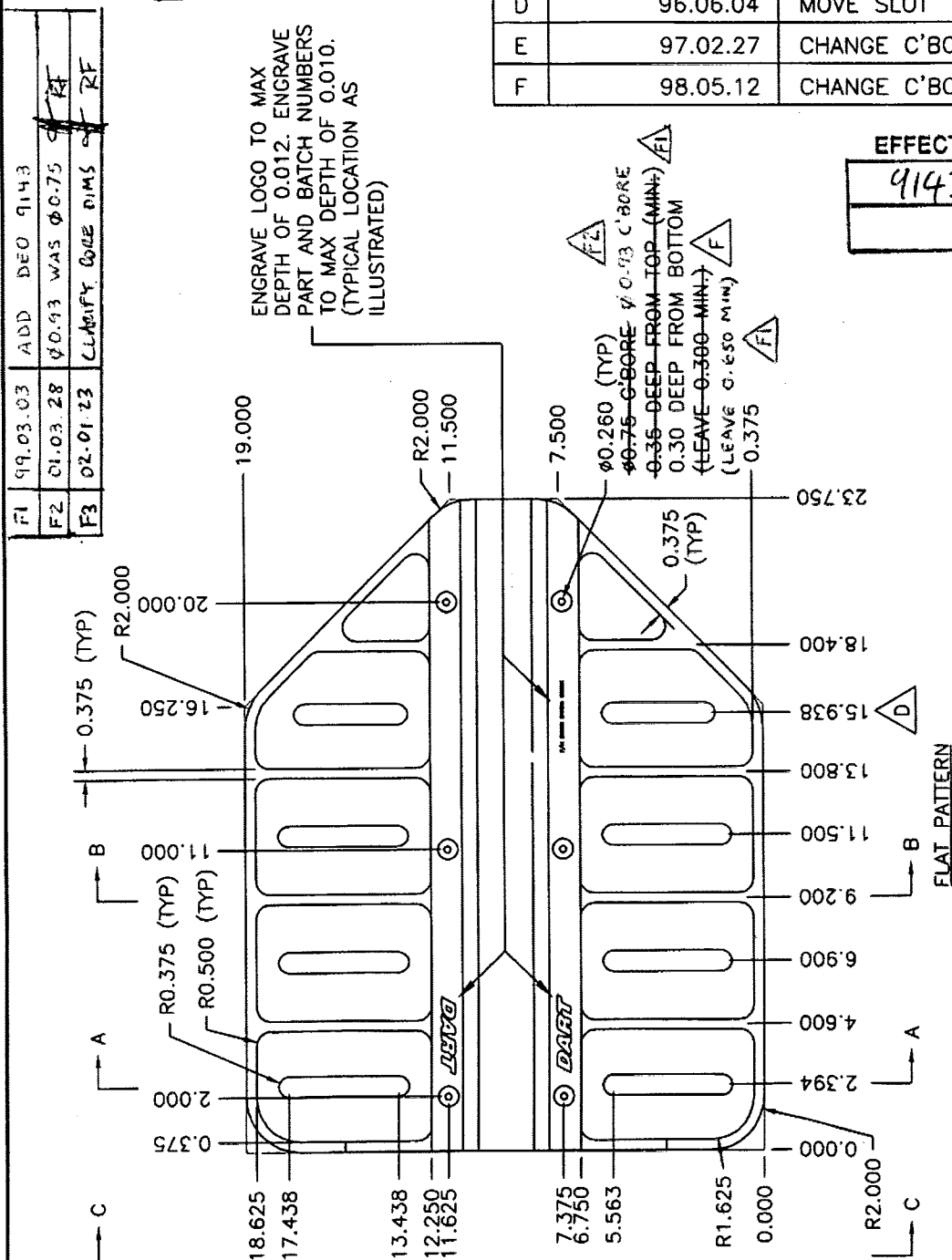
| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|-------------------------|--------------------------|
| A | 04.01.09 | New Issue | P/O K10008/D206-559-015 | KJ/RF <i>[Signature]</i> |



RELEASED
93.06.17 KE

| | | | | | |
|-------------------------------|----------|----------------------------------|--|---|--|
| DESIGN KE | | DRAWN BY KE | | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED [Signature] | | APPROVED [Signature] | | DRAWING NO. D2432 REV. F SHEET 1 OF 2 | |
| DATE 98.05.12 | | TITLE BEARPAW | | SCALE 1:6 | |
| A | 95.10.31 | NEW ISSUE | | | |
| B | 96.01.24 | RE-DESIGN | | | |
| C | 96.03.26 | CHANGE BORE AND C'BORE DEPTH | | | |
| D | 96.06.04 | MOVE SLOT | | | |
| E | 97.02.27 | CHANGE C'BORE DEPTH, BORE RADIUS | | | |
| F | 98.05.12 | CHANGE C'BORE, ADD B AND F P/N | | | |

| EFFECTIVE | DEOs |
|-----------|------|
| 9143 | |
| | |



1.000
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 257008

SHOP COPY
RETURN TO
ENGINEERING

BEND AFTER MACHINING
(D2432B ONLY)

0.950 (REF)

13.750

D2432F: FLAT BEARPAW
D2432B: BENT BEARPAW

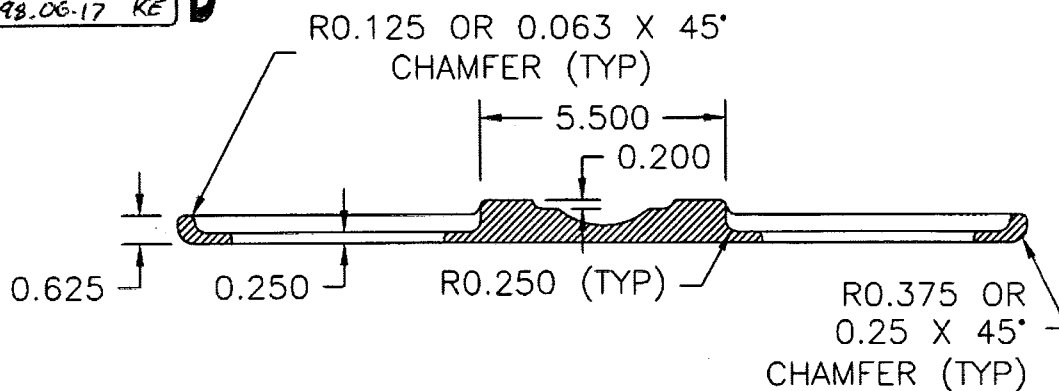
F

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

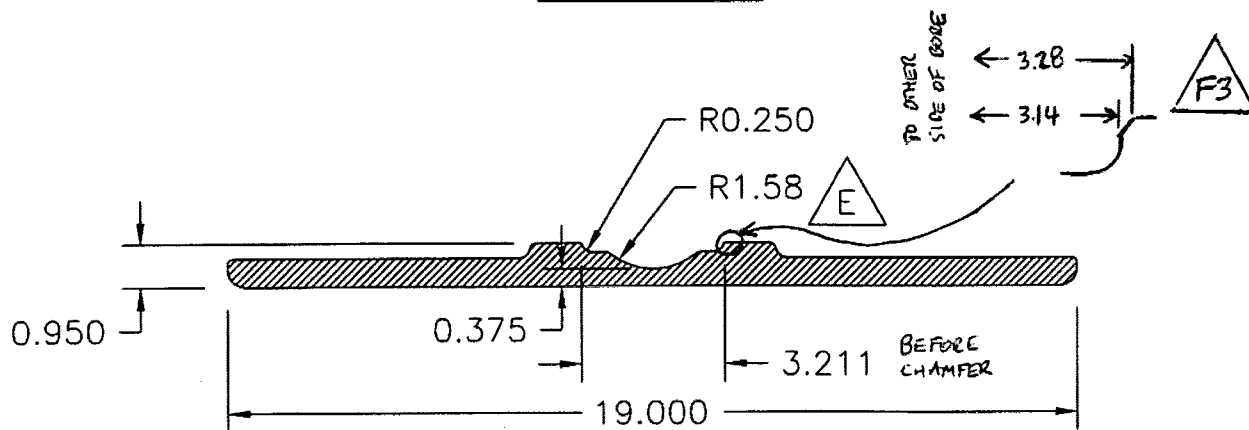


| | | | |
|------------------------|-------------------------|---|------------------------|
| DESIGN KE | DRAWN BY KE | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED [Signature] | APPROVED [Signature] | DRAWING NO. D2432 | REV. F SHEET 2 OF 2 |
| DATE 98.05.12 | TITLE BEARPAW | | SCALE 1:4 |

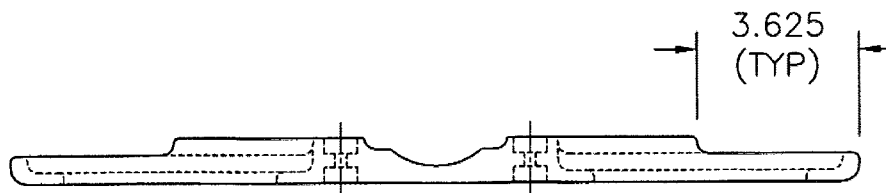
RELEASED
98.06.17 KE



SECTION A-A



SECTION B-B



SECTION C-C

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 174888